

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23666
<b>Description:</b> Bracket	<b>Part Number:</b>	D3207-1 <del>D3207-2</del>
<b>Dwg:</b> D3207 Rev. A page 1	<b>Qty:</b>	10 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC <del>KF 04.06.08</del>	Issue Traveler <del>Note: To be made in multiples of 10</del> Dwg not required	JA	05.06.25	10
2	MV	(1) Flat pattern makes either D3207-1 or <del>D3207-2</del> Cut blank: 6.5100" x 2.880" (+0.020/-0.000) grain along 2.880" Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3207-1/-2 Batch: M17225	En	05/06/25	10
3	MV	Machine as per Folio FA341 and Dwg D3207 Stack of 10	En	05/06/25	10
4	QC2	Inspect parts as they come off the CNC machine	En	05/06/25	10
5	QC8	Second check	En	05/06/25	10
6	GA	Deburr	SAP	05/06/27	10
7	GB	Form 1/2 of stack for D3207-1 as per Dwg D3207 Identify as <u>D3207-1</u>	J	05-06-30	10
8	GB	Form second 1/2 of stack for D3207-2 as per Dwg D3207 Identify as <u>D3207-2</u> N/A	J	05-06-30	10
9	QC5	Inspect work to Step 8	SL	05/06/30	10
10	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05 06 30	10
11	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	ML	05 06 30	10
12	QC3	Inspect Powder Coat	CL	05/06/30	10
13	ST	Identify and Stock D3207-1 Qty: 10 D3207-2 Qty: N/A	CL	05/06/30	10
14	AC	Parts to Stock and Prorate cost to parts per Step 13 Cost / part 9.47	SIC	05-07-04	10
15	DC	Close W/O 9.47 Inspect Level 21	JA	05/07/05	10

Rev	Date	Change	Revised By	Approved
A	04.04.15	New issue	KJ/RF	

RELEASED

04/05/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 24, 2005  
01:56 pm

Work Order No : 0023666  
Project Name : D3207-1  
Project For : WK526  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3207-1  
Description : Bracket  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 06-24-05  
Est Finish Date : 06-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00

Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

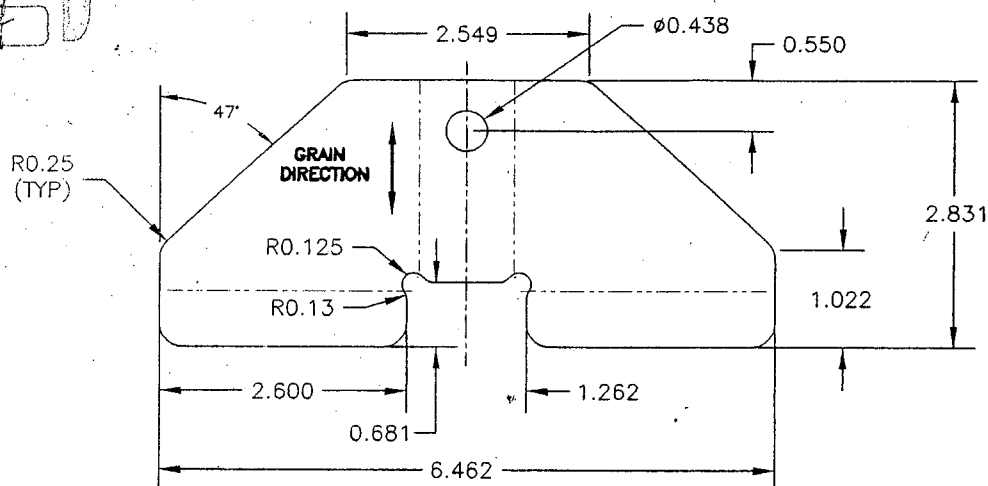
	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



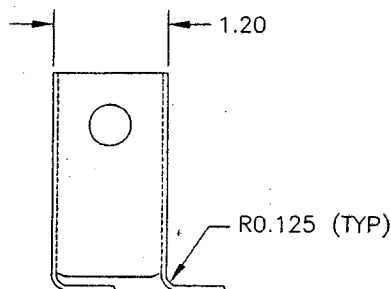
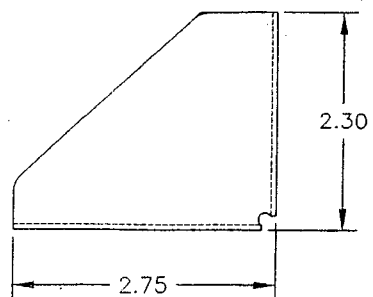
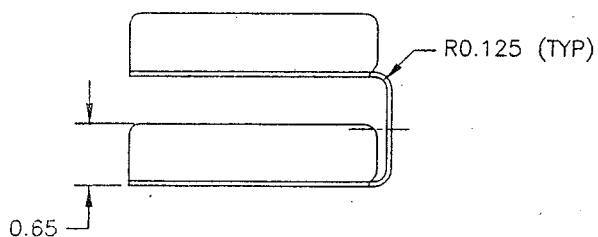
CONTROLLED COPY

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3207	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED  
04.04.05



**D3207-1/-2 FLAT PATTERN**



**D3207-1 BEND DETAIL (SHOWN)  
D3207-2 OPPOSITE**

**D3107-1/-2 BRACKET**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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